

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000503**Date Inspected:** 01-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	(BV) CWI/QC Xu Liang Zhang	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** 77m Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 Skin Plate-D Stiffener plates 1, 2 & 3 welding has been completed and it appears that stiffener 4 has also been completed but not tagged. It is now in the cool down process.

Item-2 Skin Plate-C No work is being performed at this time.

Item-3 Sub Assembly Plate-95 Plate is now in its cool down period. No work being performed.

Item-4 Sub Assembly Plate-114 Welding of the lifting devices has been completed. Tack welding will begin this evening. Welding rods to be used are the TL-508 and are in a heated rod box. Tack welding complete. Zhou Dong Yun #12179 was observed by the Caltrans QA Inspector performing the Magnetic particle test (MT) on the tack welds and were MT/OK. This Caltrans QA Inspector performed a 10% MT of the tack welding and were found to be in compliance with the project specifications. Plates #MA-102-1 to MP-1015-1 are being set in position to verify the preheating for the root welding.

Item-5 Skin Plate-A Stiffener plates 3 & 4 are being preheated for the filler welding at #3 and the root weld at #4. Stiffener plate #3 was observed being welded by Sun Hou #070409110 with a travel speed of 284.33 mm/min., Amps 301 and Volts at 31. Welding is scheduled to continue the night.

*Present at the above locations were QA Shen Xue Jun; QC Chentan; CWI/QC Le Yong Jun and CWI Ligang

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
